

Date: Tuesday, 5/23/2006 10:04:27 AM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CUP
Job Number : 27198	
Estimate Number : 12404	
P.O. Number : N/A	Part Number : D35031
This Issue : 5/23/2006 S.O. No. : N/A	Drawing Number : D3503 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 5/23/2006 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 27007	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 6/15/2006
Checked & Approved By : <u>SEE ABOVE USER & DATE</u>	Qty: 120 Um: Each
Comment : Est Rev:A New Issue 06-05-04 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R100	304 ROUND BAR
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Comment: Qty.: 0.0683 f(s)/Unit Total: 8.1900 f(s)

304 ROUND BAR

(M304R1000)

Batch:

M17002 2.5 f ~~MS~~ 06/05/24
 M100325 6.0 f ~~MS~~ 06/05/23

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA635 & DWG D3503,

FOLIO REV: AA

DWG REV: A

2-DEBURR AS REQUIRED

~~MS~~ 06/05/25
 MS 06/05/23 120

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

~~MS~~ MS 06/05/23 120

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

BC ~~MS~~ 06/05/25 120

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST417 ~~AP~~ 06/05/25 120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 19 Date: 06/05/26

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 10:04:28 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUP

Job Number: 27198

Part Number: D35031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/05/26

(20)

Job Completion



u 06.05.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

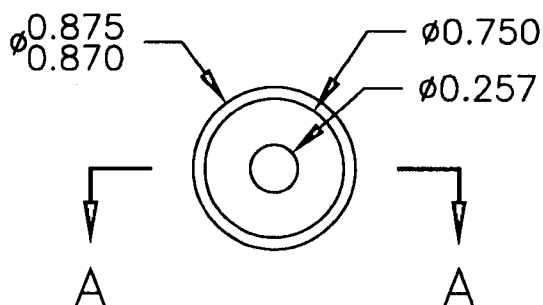
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

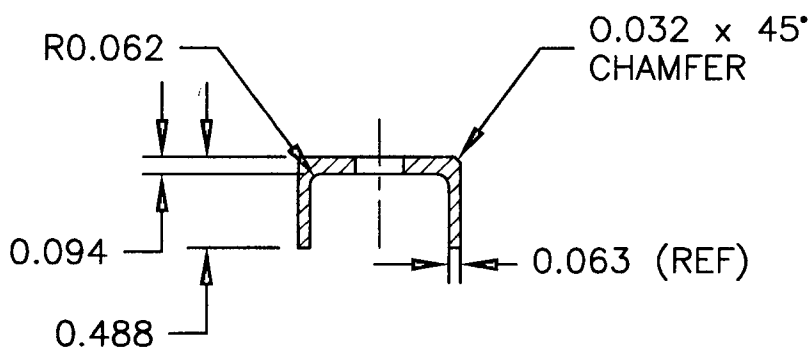


DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>Jdh</i>	APPROVED <i>PH</i>	DRAWING NO. D3503	REV. A SHEET 1 OF 1
DATE 06.04.19		TITLE CUP	SCALE 1:1
A	06.04.19	NEW ISSUE	

06-04-25 *PH*



D3503-1



SECTION A-A

REFERENCE ONLY

D3503-1 CUP

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
(REF DART MATERIAL SPEC M304RX.XXX)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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